

Date: Thursday, 3/2/2006 3:07:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING CHANNEL
 Job Number : 26030
 Estimate Number : 10605
 P.O. Number : N/A Part Number : D2585
 This Issue : 3/2/2006 S.O. No. : N/A Drawing Number : D2585 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 25328 Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 3/23/2006 Qty: 100 Um: Each
 Checked & Approved By : 06.03.02
 Comment : Est. D 04.02.16 Reformat; Add Receiving Step KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 705

Email or ship DXF file to vendor

Laser Cut D2585 as per Dwg D2585

Material release note required

2.0 D2585F Latch Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 Latch Clamp

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per dwg D2585

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1




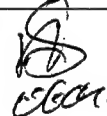

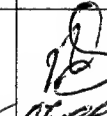
Comment: SMALL & MEDIUM FAB RESOURCE 1

Debur

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/04/19							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 26/04/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/19	6	1 piece out of Tolerance		Scrap & destroy	SB 06/04/19	 06/04/19	 06/04/19	 06/04/19

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING CHANNEL

Job Number: 26030

Part Number: D2585

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2585

SD

06/04/19

103

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joe H. N

102
PTD

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5751

06/4/19 102

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/04/21

(102)

Job Completion


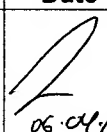
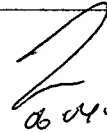




U 06-04-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/21
 QA: N/C Closed: _____ Date: _____

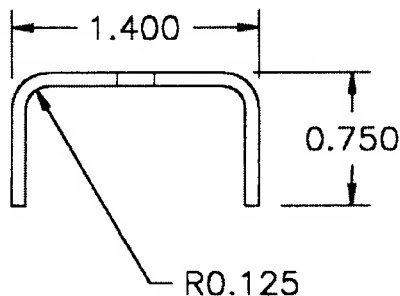
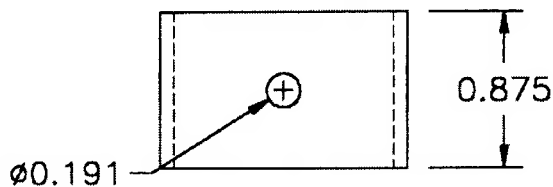
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-19	7	Found Insert with the hole sized wt, and badly damaged due to insert wt.		SCRAP: des tray	 06-04-19	 06-04-19	 06-04-19	 06-04-19

NOTE: Date & initial all entries

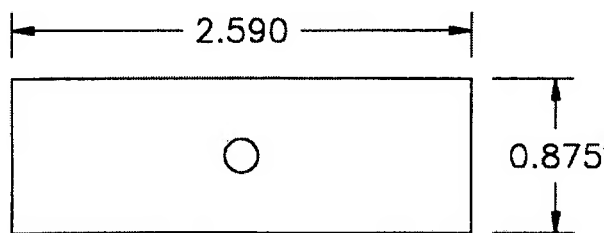


DESIGN BW	DRAWN BY MS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2585	REV. B SHEET 1 OF 1
DATE 96:07:11		TITLE MOUNTING CHANNEL	SCALE 1:1
B	97:03:14	ADD FLAT PATTERN	

RELEASED
97/03/14 DS



FLAT PATTERN



MATERIAL: 304/316 SS, 14 GAUGE (0.078)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26030

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate 185045 02

Mail To:

ALASKAN COPPER & BRASS CANADA, INC.
P.O. BOX 3546
SEATTLE, WA 98124-3546

Ship To:

ALASKAN COPPER & BRASS CANADA, INC.
225 NORTH ROAD AVENUE
COQUITLAM, BC V3K3V7
CANADA

Steel: 304

Finish: 2B

Your Order: V033868

NAS Order: AE 0249852 03

Corrosion: ASTM A262/01E; 180 Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/01, A480/01, A666/00, ASMESA240/01, SA480/01, SA666/01
QQS766D-A X MG PRM, AMS5513G X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
A96138	* 0415N6 D	.0600	60.0000	4,940	120.0000	SHEET 8	42

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15N6	.059	18.401	.333	1.726	.366	.051	8.161	.029	< .001	.395

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail H Tail
A96138	0415N6	F T	96.06	49.79	48.68	85.00	88.00

MILL TEST

MILL TEST CERTIFICATES

705

870

YIH MAU CORP.

ORIGINAL

INVOICE NO. : F05M920

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION :

AISI 304

CUSTOMER :

OLBERT METAL SALES LIMITED

I.A.: 高雄縣路竹鄉廣興路345號
 345, SHUN AN RD. LU CHU HSIANG
 KAOHSIUNG TAIWAN R.O.C.
 TEL: (07) 6972845 FAX: (07) 6978006
 CERTIFICATE NO. F05M920
 DATE OF ISSUE: 10/28/2005

TOTAL P.04

SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50mm					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304/NO.4 (FILM ON MAIN SIDE WITH BACK-PASS)																		
24GA / 48" X 96"	1	1,367	3,014	NSE53719	48S71574-12	266	641	58	78	150	6	37	72	25	6	804	1800	3.7
24GA / 48" X 120"	1	1,149	2,533	NSE53719	48S71574-13	266	641	58	78	150	6	37	72	25	6	804	1800	3.7
24GA / 48" X 120"	1	946	2,086	NSE53719	48S71574-14	266	641	58	78	150	6	37	72	25	6	804	1800	3.7
16GA / 36" X 96"	1	1,809	3,984	YU235551	48S12437-316	323	647	50	78	149	4.2	51	124	35	8	806	1817	2.7
16GA / 36" X 120"	1	1,082	2,385	YU235551	48S12437-313	323	647	50	78	149	4.2	51	124	35	8	806	1817	2.7
16GA / 36" X 120"	1	1,082	2,385	YU235551	48S12437-314	323	647	50	78	149	4.2	51	124	35	8	806	1817	2.7
16GA / 60" X 96"	1	1,350	2,976	YU139585	48S14145A-21	302	654	58	78	144	4.7	49	125	32	6	805	1822	3.1
16GA / 60" X 120"	1	1,082	2,385	YU235720	48S14157A-13	306	647	51	80	155	4.8	53	112	31	6	808	1832	3.1
16GA / 60" X 120"	1	1,082	2,385	YU235720	48S14157A-14	306	647	51	80	155	4.8	53	112	31	6	808	1832	3.1
14GA / 48" X 96"	1	1,804	3,978	YU235525	48S11699H-16	316	692	51	83	164	4.8	53	120	29	5	804	1808	3.3
14GA / 48" X 120"	1	1,145	2,524	YU235525	48S11699H-18	316	692	51	83	164	4.8	53	120	29	5	804	1808	3.3
14GA / 48" X 120"	1	1,145	2,524	YU235525	48S11699H-17	316	692	51	83	164	4.8	53	120	29	5	804	1808	3.3
11GA / 48" X 120"	1	1,852	3,642	YU139676	48S14905A-112	306	656	51	84	166	6	48	111	29	11	805	1825	2.2
11GA / 48" X 120"	1	1,852	3,642	YU139676	48S14905A-113	306	656	51	84	166	6	48	111	29	11	805	1825	2.2
TOTAL:		14	17,527	38,638														
Remarks: NO MERCURY CONTAMINATION Bend test: good for all Heat NO.																		
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE																		

P50908PC001V

YIH MAU CORP.

Manager of Quality Assurance Section